

ITEM	Qty	Part Number	Description
	X	D3582-041	SKIDTUBE ASSEMBLY
1	1	D2962-150	EXTRUSION
2	1	D2964	CAP
3	1	D2965	CAP
4	1	D2971	CROSS BOLT SPACER
5	1	D3508-3	WEARPLATE
6	1	D3508-9	WEARPLATE
7	1	D3508-11	WEARPLATE
8	1	D3508-13	WEARPLATE
9	1	D3558-3	GASKET
10	1	D3558-9	GASKET
11	1	D3558-11	GASKET
12	1	D3558-13	GASKET
13	1	D3584-1	WEB
14	3	D3662-1	CROSS BOLT SPACER
15	1	D3662-3	CROSS BOLT SPACER
16	2	D5304-1	CROSS BOLT SPACER
17	2	D5520-1	DOUBLER
18	28	AN3C4A	BOLT
19	2	AN3-5A	BOLT
20	2	AN4-4A	BOLT
21	28	NAS1149C0332R	WASHER (AN960C10L)
22	2	NAS1149D0332J	WASHER (AN960JD10L)
23	2	NAS1149D0416J	WASHER (AN960JD416L)
24	36	AELS-1032-130	INSERT
25	2	ALST-428-165	INSERT
26	68	CR3212-5-05	CSK RIVET, CHERRY MAX

POSITIVE RECALL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 18.2 lbs
- 8) WELDING: PER DART QSI 004.
- 9) INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- 10) USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 11) DO NOT INSTALL AN3C4A BOLTS AND NAS1149C0332R WASHERS IN INDICATED LOCATIONS
- 12) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL Ø0.161 THRU SKIDTUBE AND DOUBLER USING DT10309.
- COUNTERSINK Ø0.286 x 100° (34 PL) PER DOUBLER AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS.

E	MOVE VIEWS FROM SHT 1 TO SHT 2. ADD ITEMS 17 & 26 AND NOTE 12-13. Ø0.187 HOLE WAS Ø0.75. ADD SHT 3. ADD DETAIL J. SECTION F-F ADD D5520-1. SCALE ON VIEWS WAS 3X.	AJS	17.03.27
D	D5304-1 WAS D2973; REVISE BOM & SECTION F-F & SECTION NOTES (ZN B7-3, A8-3); REF NCR16-6160	RF	17.01.09
C	D3492 PLUG ASSEMBLIES REMOVED. REFORMAT NOTES SHT 1	AP	15.11.02
B	29.86 WAS 29.87 (ZN C2-1), INCORPORATED DEO D3582-A-1 (ZN D5-1), FORMAT TO CURRENT STD	RF	15.02.20
A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION		
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED		TITLE BK 117 SKIDTUBE ASSEMBLY	
DE APPR.			
DATE	17.03.27		
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A

B

C

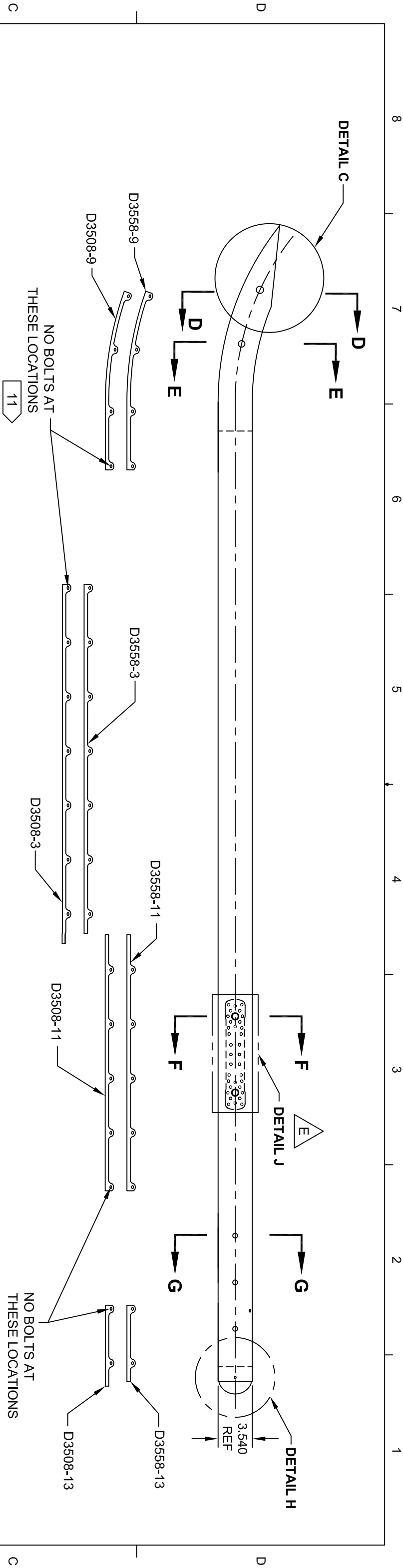
D

A

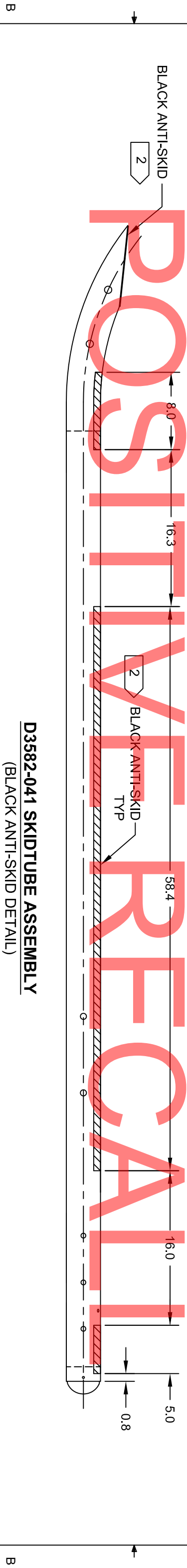
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C

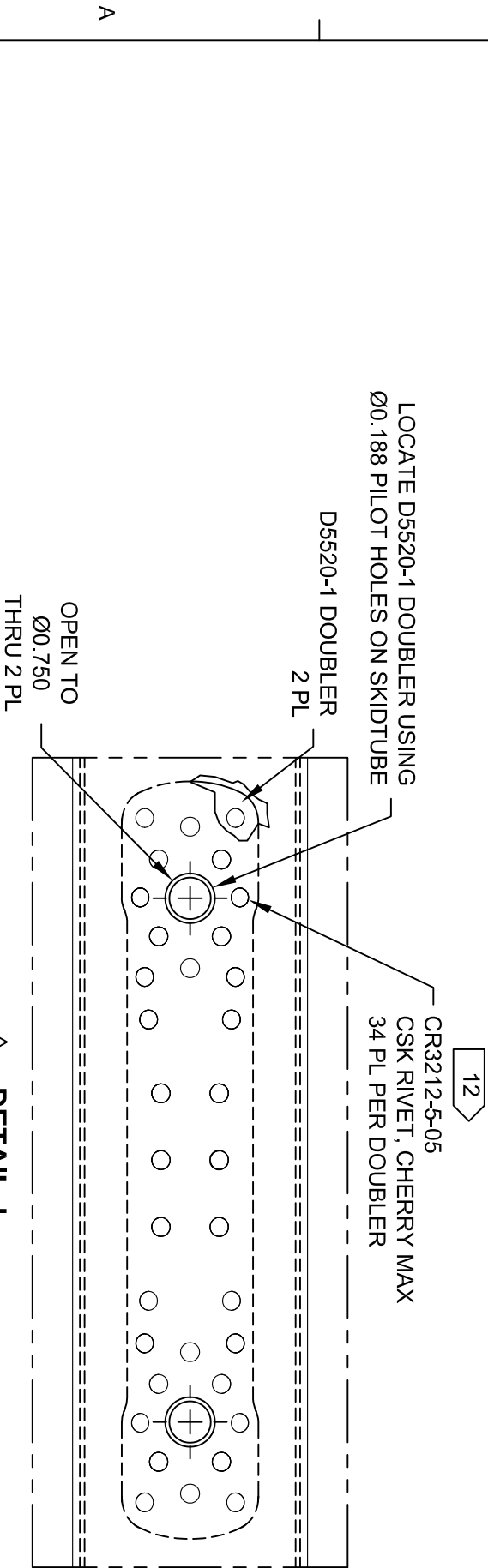
D



D3582-041 SKIDTUBE ASSEMBLY
(ASSEMBLY DETAIL)



D3582-041 SKIDTUBE ASSEMBLY
(BLACK ANTI-SKID DETAIL)



12

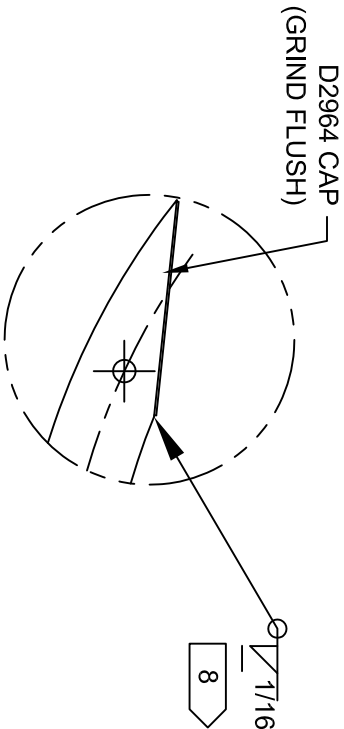
LOCATE D5520-1 DOUBLER USING
Ø0.188 PILOT HOLES ON SKIDTUBE

D5520-1 DOUBLER
2 PL

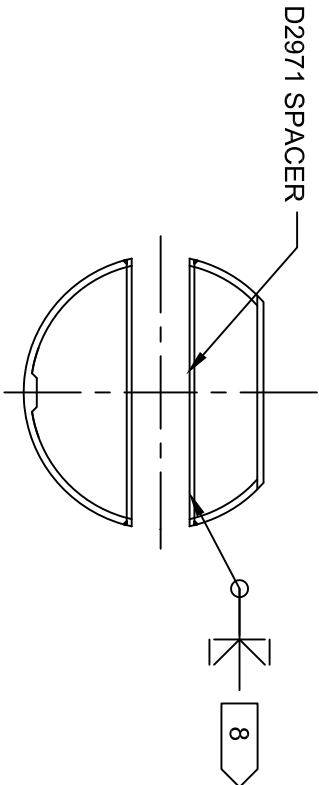
OPEN TO
Ø0.750
THRU 2 PL

DETAIL J
SCALE 3X

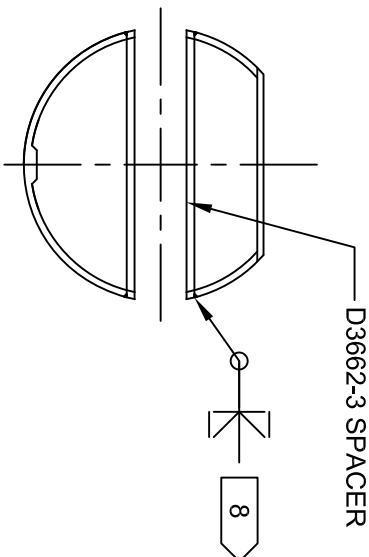
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	AJS		
CHECKED		DRAWING NO. D3582	
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APPROVED		TITLE BK 117 SKIDTUBE ASSEMBLY	
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		REV. E	SHEET 2 OF 4
		SCALE	NTS



DETAIL C
SCALE 4X



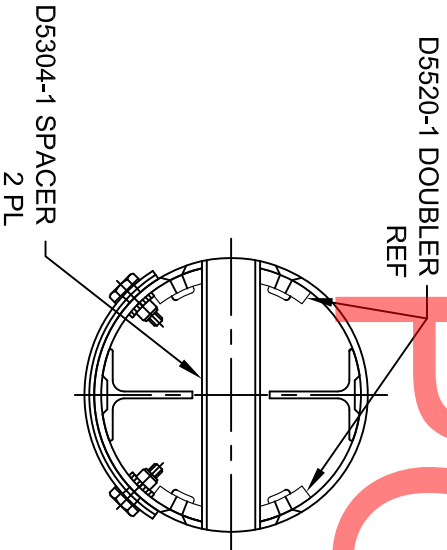
SECTION D-D
SCALE 4X



SECTION E-E
SCALE 4X

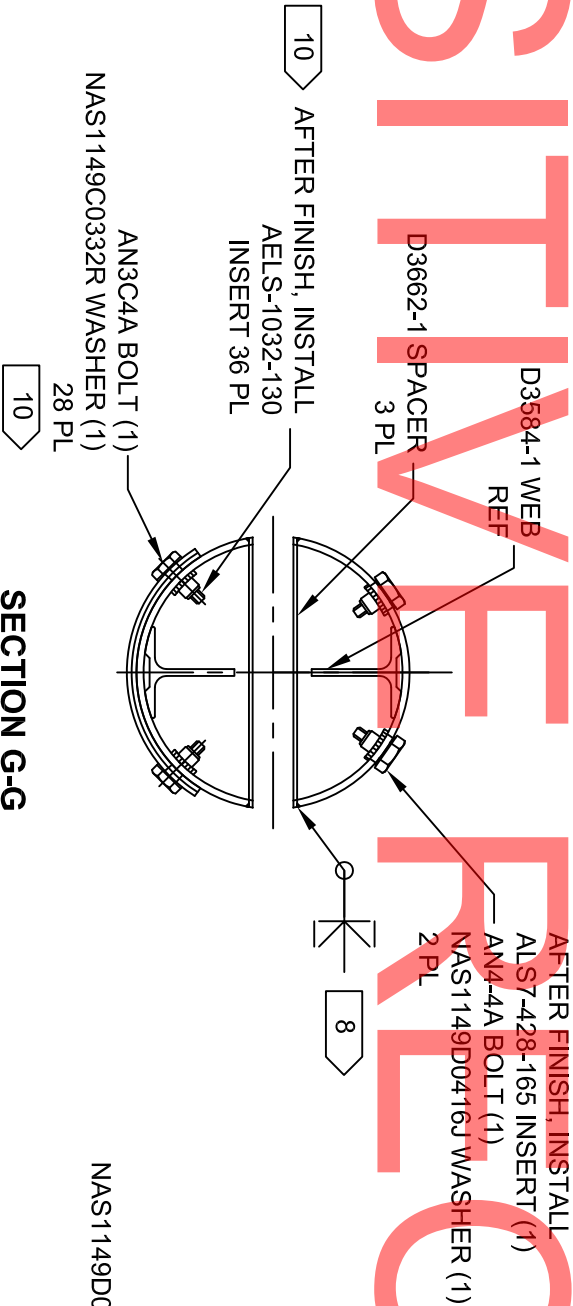
- SECTION D-D NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D2971 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.750 DRILL TO REMOVE SPILL OVER

- SECTION E-E NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-3 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.672 DRILL TO REMOVE SPILL OVER



SECTION F-F
SCALE 4X

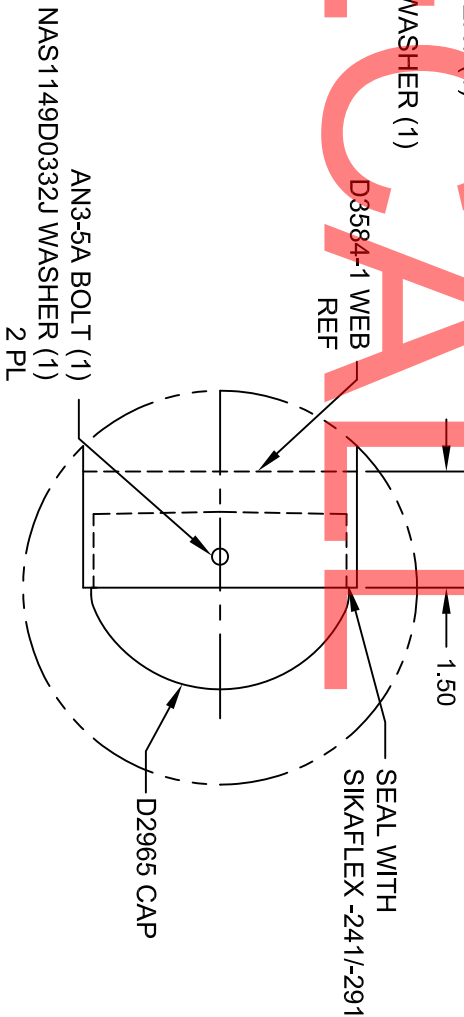
- SECTION F-F NOTES**
AFTER BENDING AND DRILLING ASSY
PERFORM THE FOLLOWING:
1. INSERT D5304-1 SPACER
 2. SWAGE TO Ø0.565 +0.005/-0.000 X 1.0
 3. OPEN THRU HOLE TO Ø0.625
 4. GRIND FLUSH



SECTION G-G
SCALE 4X

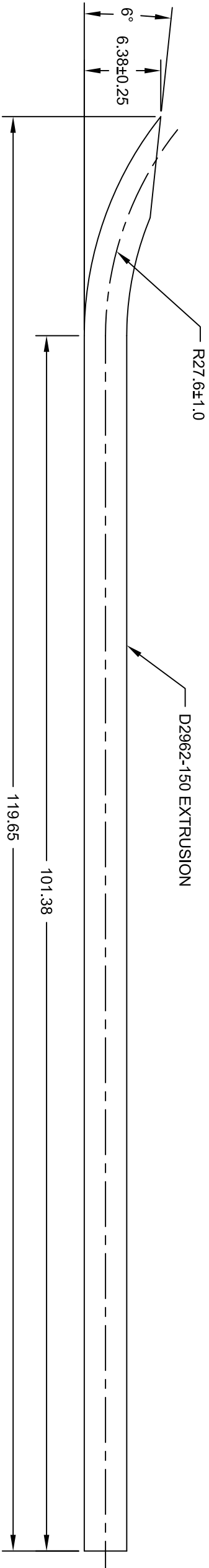
- SECTION G-G NOTES**
AFTER BENDING AND DRILLING ASSEMBLY
PERFORM THE FOLLOWING:
1. CHAMFER HOLE 0.030 x 45°
 2. INSERT D3662-1 SPACER (3 PLACES)
 3. WELD INTO PLACE AND GRIND FLUSH
 4. PASS Ø0.515 DRILL TO REMOVE SPILL OVER

DETAIL H
SCALE 4X

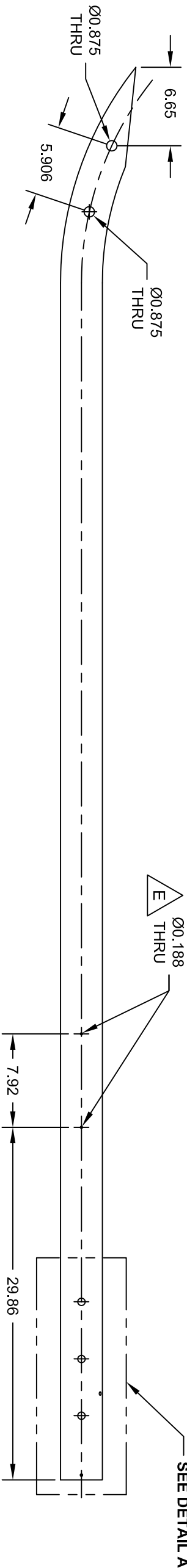


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CHECKED			
MFG. APPR.			
APPROVED		TITLE	REV. E
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	SHEET 3 OF 4
DATE	17.03.27		SCALE
			NTS

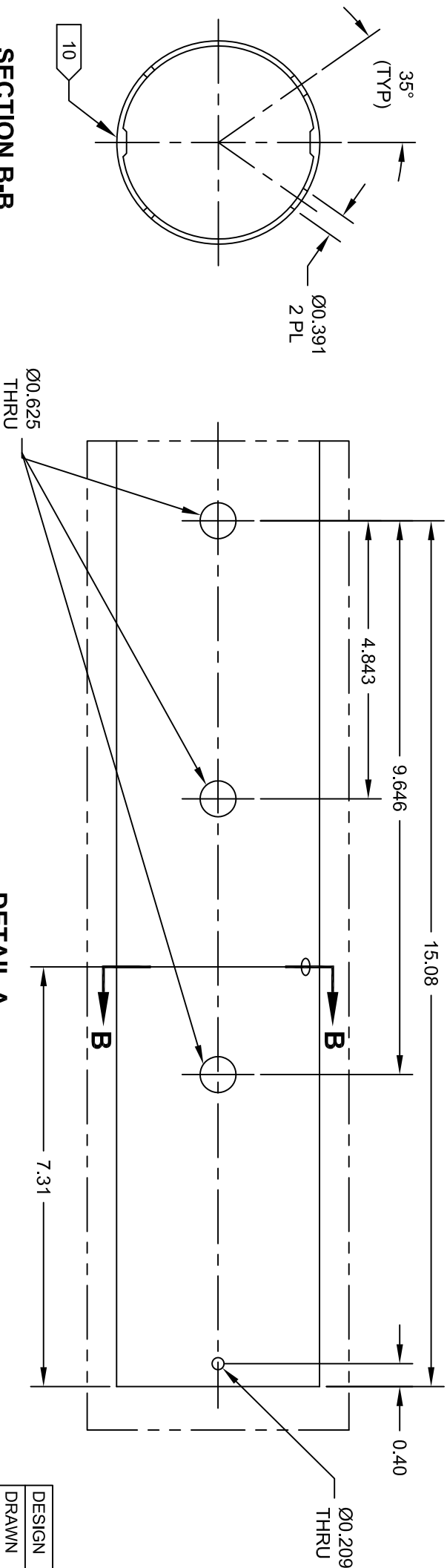
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D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 5X

DETAIL A
SCALE 5X

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MFG. APPR.		D3582	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BK 117 SKIDTUBE ASSEMBLY	NTS
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